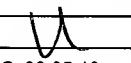


Step 29/04

Dart Aerospace Ltd.

Date: Wednesday, 23/04/2008 7:02:34 AM
User: Linda Lacelle

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET		
Job Number	38766		Part Number	: D23623		
Estimate Number	10260		Drawing Number	: D2362 REV E1		
P.O. Number	:		Project Number	: N/A		
This Issue	23/04/2008	S.O. No. :	Drawing Revision	: E1		
Prsht Rev.	NC		Material	:		
First Issue	11	Type : MACHINED PARTS	Due Date	: 29/04/2008		
Previous Run	37459			Qty:	8	Um: Each
Written By	:					
Checked & Approved By	:					
Comment	Est: G 00.05.18 Added inspection level 8 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2265	Step Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Step Support Pick: Qty Part Number Description Batch 1 D2265 Step Support 37477	 <i>Just 29/04/28 8</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 <i>BG 08-04-28 8</i>
		Comment: Machine per folio D2362-3	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>BG 08-04-28 8</i>
		Comment: Inspect Level 2	
4.0	QC8	SECOND CHECK	 <i>29/08/04/28 8</i>
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <i>29/08/04/28 8</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	
6.0	POWDER COATING	POWDER COATING	 <i>29/08/04/28 8</i>
		Comment: POWDER COATING Powder Coat Gloss White (Ref 4.3.5.1)as per Dart QSI 005 4.3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 23/04/2008 7:02:34 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 38766

Part Number: D23623

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BK 08-04-28

(1)

Comment: INSPECT POWDER COAT

8.0 D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1 D2397-1 Rubber

B38053 (1)

B36117 (7x)

SB 08/04/1ng

9.0 D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1 D2397-3 Rubber

B36118 (7x)

B38054 (1) 83 08/04/29

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch *m107860*

ml08/04/29 18

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



(8)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *4X*

8/4/29

SP

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/29 off

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

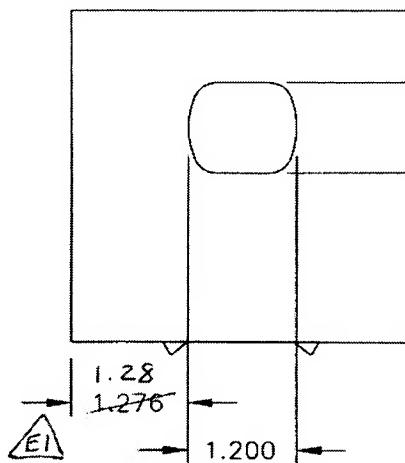
NOTE: Date & initial all entries

EI

03.10.07

TOLERANCE CHANGE

VIEW A-A



0.80
EI
0.800
1.000
REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

0.257 X 0.75 SLOT

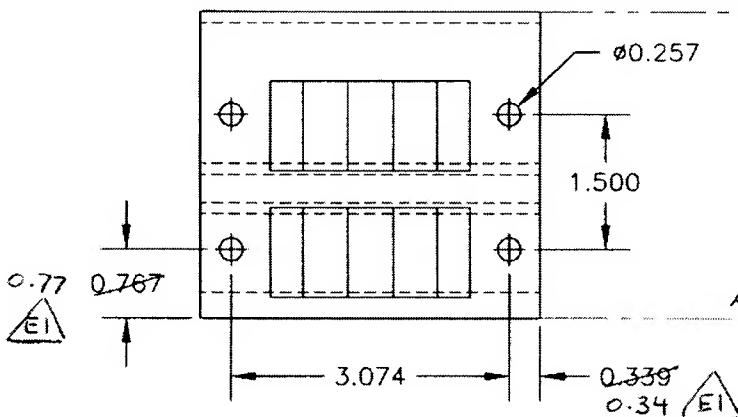
RELEASED
98.12.14
KE



DESIGN BW	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED JF	DRAWING NO. D2362
DATE 98.12.04	STEP SUPPORT BRACKET	REV. E SHEET 1 OF 3 SCALE 1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW
CJ 03.15 CP

DESIGN NEEDS, BUT CHECK WITH
3D BEFORE MANUFACTURE
OK f
D2362-3



D2362-3

NOTES:

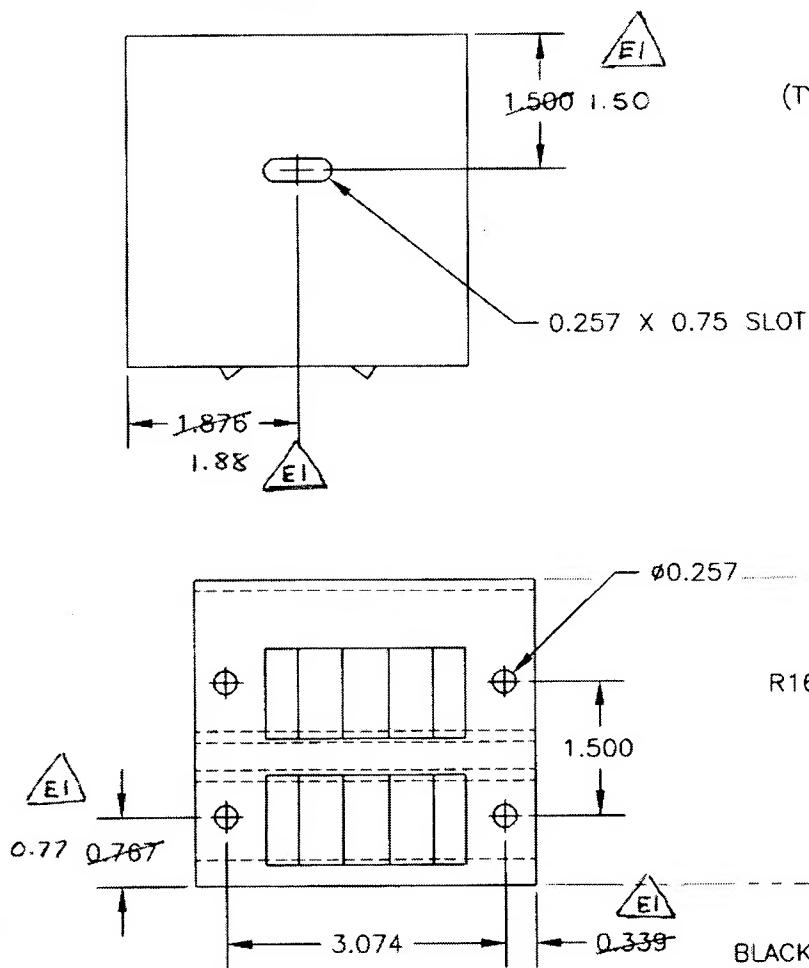
MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright 1995 by DART AEROSPACE LTD

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080

Technical drawing showing a bracket assembly. The top horizontal dimension is labeled 0.100. The vertical dimension on the left is labeled R16.680. A callout arrow points to the bottom right of the bracket assembly, with the text 'BLACK ANTI-SKID PAINT FOR D2362-1' below it. The letter 'A' is also present on the drawing.

D2362-1 & D2362-5

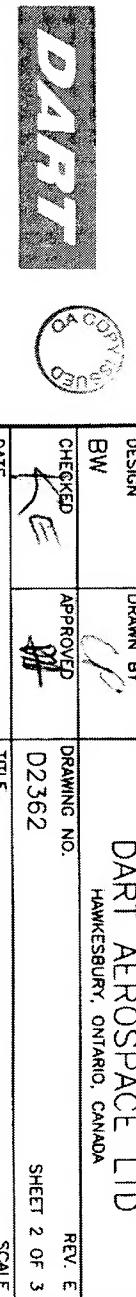
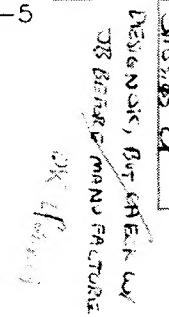
NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2362-041 (SHOWN)

02502 041 [REDACTED]
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

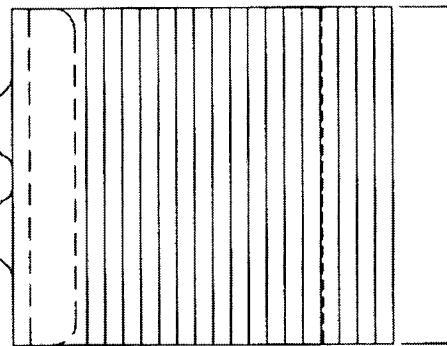
REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DAR
OSI 00

A technical drawing of a structural component, likely a girder or plate, showing its thickness and various dimensions. The component is 3.074 units wide and 1.500 units thick. It features two rows of holes, each row containing four holes. The distance from the bottom edge to the top of the top row of holes is 0.767. The distance from the bottom edge to the top of the bottom row of holes is 0.339. The distance between the two rows of holes is 0.34. The thickness of the component is 0.257. A note 'EI' is present in the bottom right corner.



3.750 (REF)

DR. BERNARD MANUFACTURE

DESIGN OK, BUT CH

WEEK WITH

RELEASE
905.12.14
KG

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>KC</i>	<i>MM</i>	D2362	SHEET 3 OF 3
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	

DART AEROSPACE LTD	Work Order:	38766
Description: STEP SUPPORT BRACKET	Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: 	Audited by: 	Prototype Approval: 
Date: 08/04/28	Date: 08/04/28	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

CUSTOMER RETURN

Initiator: Team Kerr
 Company: World Wind Maint.
CNWRBL01
 Phone No. 425-793-8400

Date: May 9/08
 Invoice #: 6443
 Order Entry #: 5924

Attach Copy of DHS Return Authorization # 4051

Reason for return: Customer - M/S order understood Catalogue
ordered correct bracket.

Receiving:				Prepaid	Collect
Date Received: <u>8/5/23</u> Freight Company: <u>FEDEX GROUND</u>				Distribute to QC	
#	Part #	Batch #	Description	Advise QA	Date:
4	<u>D2362-3</u>	<u>38766</u>	<u>Step Support Bracket</u>	<u>DADE</u>	<u>8/5/23</u>

Condition of packaging: Good Photograph required: yes no

Paperwork attached: P/S Invoice _____ ARC _____ Docs _____ Other _____

QC:

Quarantine: _____ Location: _____

Condition of Part: Good

Inspect:			Initial:	QC Approval	Scrap
#	Part #	Batch #	QC Comments	Initial	W/O #
4	<u>D2362-3</u>	<u>38766</u>	<u>Return to stock as per WO</u>	<u>DADE</u>	<u>39471</u>

QA Coordinator:

Advise GM as to findings: Initial: _____ Date: _____

Comments:

Issue credit: yes <input type="checkbox"/> no <input checked="" type="checkbox"/>	Invoice Amount: _____
GM Approval: _____	Less Replacement: _____
	Restock Fee: _____
	Freight: _____
	Net Credit: _____
	DHS <input type="checkbox"/> Customer <input checked="" type="checkbox"/>

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit